Date: Monday, 5/15/2006 10:44:29 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: CLAMP
Job Number	: 27091		
Estimate Number	: 10584		
P.O. Number	: N/A	**Part Number**	: D1048
This Issue	: 5/15/2006 **S.O. No.** : N/A	**Drawing Number**	: D1048 REV A
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : PURCHASED PARTS	**Drawing Revision**	: A
Previous Run	: 27076	**Material**	: N/A
Written By	: SEE A COMMENT BELOW	**Due Date**	: 5/30/2006 **Qty:** 50 **Um:** Each
Checked & Approved By	: 06.05.15		
Comment	: Est: B 02.02.22 Re-format NG		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING

Comment: PURCHASING
Issue P/O: 1263
Stamp and deburr per dwg D1048
Material: Stainless steel T304#2B Supply release not for Material.

C2060105116 (50)
laser cut flat pattern

2.0	D1048F	Clamp

Comment: Qty.: 1.0000 U(s)/Unit Total : 50.0000 U(s)
CLAMP

3.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Recieive & Inspect for Transit Damage
Ensure Material Release Note is attached

M 6/5/25 (50)

4.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

06.05.29 (50)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.
2-Form as per dwg D2010 using DT8053

SAD ~~06.06.01~~
06.06.01

47 (AD)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Mfg / Design Mgr	**Approval** QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Design Mgr	**Action Description** Design Mgr	**Sign & Date**	**Verification** Section C	**Approval** Design Mgr	**Approval** QC Inspector
06.05.31	5	3 Parts were not formed properly. Placed wrong in bend jig. Bend not centered in the part.	06.06.05	Scrap & destroy.	SAD 06.06.05 05-31	06-05-31	06.06.05	06-05-31

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** _____ **Date:** 06/06/05

NOTE: Date & initial all entries **QA: N/C Closed:** _____ **Date:** _____

H:\forms\Quality Assurance\approved forms\NCRWO revC

Date: Monday, 5/15/2006 10:44:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** CLAMP

Job Number: 27091 **Part Number:** D1048

Job Number: 

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	EP 06/05/31 x47
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	PL 06/06/01 (47)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: STO9	06/06/01 (47)
10.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	(47) 06/06/02

Job Completion 

06/06/02

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Mfg / Design Mgr	**Approval** QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Design Mgr	**Approval** QC Inspector
			Initial Design Mgr	**Action Description** Design Mgr	**Sign & Date**			

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ **Date:** _____

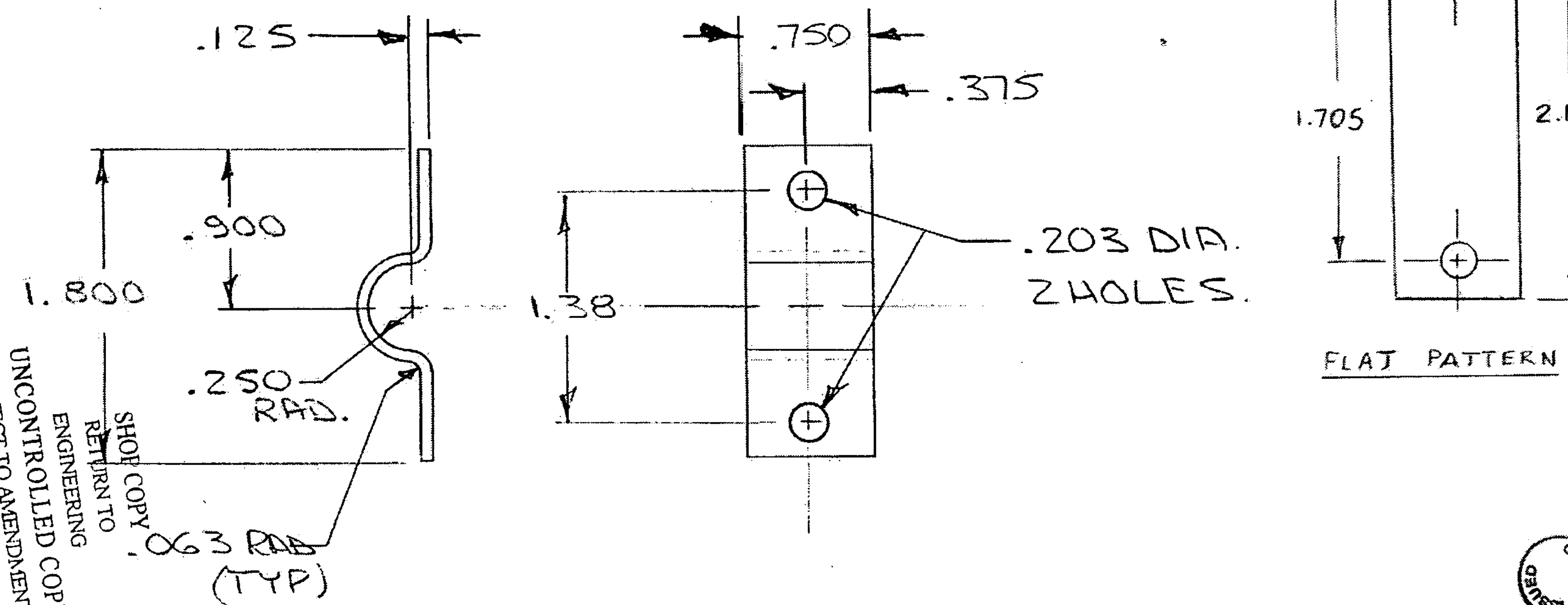
RELEASED 97/09/02

NOTES:

1) MATERIAL
STAINLESS STEEL
T304 #2B .062 THICK

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27091

CA COPY ISSUED

D1048

	A	REVISION	
	RF	DRAWN	
		APPROVED	
	01.12.05 ADD FLAT PATTERN	DESCRIPTION OF CHANGE	

THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.

REQUIREMENTS — UNLESS OTHERWISE SPECIFIED

GENERAL	LIMITS
1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 ✓ 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL - S - 7742 5. HOLES PER AND 10387	1. TOLERANCES — .XX ± .030 .XXX ± .010 2. ANGLES ± ½° 3. PARALLELISM ± .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005

REPORT ALL DISCREPANCIES — DO NOT SCALE

RIVET CODE SHALL BE PER NAS 523

BASIC CODE	DIA. DASH NO. N=HEAD NEAR SIDE F=HEAD FAR SIDE
D=DIMPLE DIGIT=NO OF SHEETS C=COUNTERSINK	LENGTH DASH NO. W=SPOTWELD

BASIC CODES
BJ=MS20470AD
BB=MS20426AD

PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR

CONTRACT NO.

		DATE
DRAWN	BRADLEY	July 1/91
DESIGN	BRADLEY	
STRESS		
CHECKED		
CLIENT		

DART AERO ACCESSORIES INC.
VANCOUVER CANADA

TITLE: CLAMP

CODE: | DWG NO.: D1048 | REV.: A
SCALE: 1:1 | SHT 1 OF 1

A

2 1

GERDAU AMERISTEEL

CAMBRIDGE STEEL MILL
160 ORION PLACE
CAMBRIDGE ON N1T 1R9 CAN
(519) 740-2488

Chemical and Physical Test Report

MADE IN CANADA

N-037186

SHIP TO	INVOICE TO	SHIP DATE
VEDDER TRANSPORT C/O WILKINSON STEEL AND METALS 586 RIVERSIDE ROAD ABBOTSFORD, BC	WILKINSON STEEL & METALS VAN PREMETALCO INC 888 SOUTHEAST MARINE DR. VANCOUVER, BC V5X 2V3	01/12/06 CUST. ACCOUNT NO 60073699

SHAPE + SIZE	GRADE	SPECIFICATION	SALES ORDER	CUST P.O. NUMBER
A2 X 2 X 1/4	44W	CSA-G40.21-300W-98(44W); ASTM A36/A36M-04	5113567-03	P51121MV001

HEAT I.D.	C	Mn	P	S	Si	Cu	Ni	Cr	Mo	V	Nb	B	Sn	Al	Zr	C Eqv
N545178	.16	.69	.009	.034	.19	.25	.12	.14	.060	.004	.000	.0000	.017	.001	.002	.366

Mechanical Test: Yield 50258 PSI, 346.52 MPA Tensile: 74435 PSI, 513.21 MPA %El: 27.0/8in, 27.0/200MM Red R 26.7 : 1
Mechanical Test: Yield 49665 PSI, 342.43 MPA Tensile: 74737 PSI, 515.29 MPA %El: 27.0/8in, 27.0/200MM Red R 26.7 : 1

SHAPE + SIZE	GRADE	SPECIFICATION	SALES ORDER	CUST P.O. NUMBER
A2 X 2 X 1/4	44W	CSA-G40.21-300W-98(44W); ASTM A36/A36M-04	5113567-03	P51121MV001

HEAT I.D.	C	Mn	P	S	Si	Cu	Ni	Cr	Mo	V	Nb	B	Sn	Al	Zr	C Eqv
N545180	.15	.63	.011	.034	.18	.27	.09	.16	.043	.004	.001	.0000	.019	.001	.002	.325

Mechanical Test: Yield 48109 PSI, 331.7 MPA Tensile: 70847 PSI, 488.47 MPA %El: 28.5/8in, 28.5/200MM Red R 26.7 : 1
Mechanical Test: Yield 48088 PSI, 331.55 MPA Tensile: 71075 PSI, 490.04 MPA %El: 28.0/8in, 28.0/200MM Red R 26.7 : 1

SHAPE + SIZE	GRADE	SPECIFICATION	SALES ORDER	CUST P.O. NUMBER
A2 X 2 X 1/4	44W	CSA-G40.21-300W-98(44W); ASTM A36/A36M-04	5113567-03	P51121MV001

HEAT I.D.	C	Mn	P	S	Si	Cu	Ni	Cr	Mo	V	Nb	B	Sn	Al	Zr	C Eqv
N545719	.18	.66	.010	.024	.18	.21	.11	.11	.041	.003	.003	.0001	.051	.001	.002	.342

Mechanical Test: Yield 50567 PSI, 348.65 MPA Tensile: 73436 PSI, 506.32 MPA %El: 27.0/8in, 27.0/200MM Red R 26.7 : 1
Mechanical Test: Yield 50554 PSI, 348.56 MPA Tensile: 73611 PSI, 507.53 MPA %El: 27.0/8in, 27.0/200MM Red R 26.7 : 1

This material, including the billets, was produced and manufactured in Canada.

A.J. Turner
Quality Assurance Manager
Mill Group

THE ABOVE FIGURES ARE CERTIFIED EXTRACTS FROM THE ORIGINAL CHEMICAL AND PHYSICAL TEST RECORDS AS CONTAINED IN THE PERMANENT RECORDS OF COMPANY.

Mgr. Metallurg. Svcs.
CAMBRIDGE STEEL MILL

P51013PC002

MILL TEST CERTIFICATE

872

燁茂實業股份有限公司
YIEH MAU CORP.

ORIGINAL

工廠:高雄縣路竹鄉順安路345號
345, SHUN AN RD. LU CHU HSIANG
KAOHSIUNG TAIWAN R.O.C.
TEL:(07)6972835 FAX:(07)6975006

CERTIFICATE NO:F05MA29
DATE OF ISSUE:11/30/2005

INVOICE NO. : F05MA29
COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

SPECIFICATION : AISI 304
CUSTOMER : OLBERT METAL SALES LIMITED

PO 1263 16GA 304 S.S.

SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test GL=50 m/m					Chemical Composition (%)								
		KGS	LBS			Y.S. (N/mm²)	T.S. (N/mm²)	E L (%)	HRB	H V	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100	
AISI 304/NO.4 (FILM ON MAIN SIDE WITH BACK-PASS)																			
16GA / 48" X 96"	1	1,476	3,254	YU236038	4AS16493A-32	297	659	51	79	149	4.3	48	105	32	12	805	1818	2.9	
16GA / 48" X 96"	1	1,479	3,261	YU234718	4AS16505B-21	316	690	50	81	158	4.1	55	124	31	7	804	1816	3.1	
16GA / 48" X 96"	1	1,479	3,261	YU234718	4AS16505B-22	316	690	50	81	158	4.1	55	124	31	7	804	1816	3.1	
16GA / 48" X 120"	1	1,530	3,373	YU236038	4AS16494A-11	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9	
16GA / 48" X 120"	1	1,535	3,384	YU236038	4AS16494A-12	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9	
16GA / 48" X 120"	1	1,538	3,391	YU236038	4AS16494A-13	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9	
16GA / 48" X 120"	1	1,540	3,395	YU236038	4AS16494A-14	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9	
16GA / 48" X 120"	1	1,541	3,397	YU236038	4AS16494A-15	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9	
16GA / 48" X 120"	1	727	1,603	YU236038	4AS16494A-16	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9	
16GA / 48" X 120"	1	1,533	3,380	YU234718	4AS16505B-23	316	690	50	81	158	4.1	55	124	31	7	804	1816	3.1	
16GA / 48" X 144"	1	1,338	2,950	YU236038	4AS16493A-31	297	659	51	79	149	4.3	48	105	32	12	805	1818	2.9	
12GA / 48" X COIL	1	3,308	7,293	YU139969	13S18207A-11	310	625	52	83	163	4.5	46	127	31	7	816	1817	2.8	
TOTAL:	12	19,024	41,942																

Remarks: NO MERCURY CONTAMINATION Bend test good for all Heat NO.

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

06-05-29

YIEH MAU CORP.

Lin Kun Hsing

Manager of Quality Assurance Section